

Date: Monday, 25/09/2006 11:11:52 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PANEL
Job Number	: 28627		
Estimate Number	: 10908	Part Number	: D33307
P.O. Number	: N/A	Drawing Number	: D3330 REV B1
This Issue	: 25/09/2006 S.O. No. : N/A	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: B1
First Issue	: N/A Type : PURCHASED PARTS	Material	: N/A
Previous Run	: 28627	Due Date	: 05/10/2006
Written By	: <u> </u>	Qty:	8 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est. A05.01.13 New issue KJ/JLM Est Rev:B Now on Waterjet 06-09-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet .125
-----	-----------	----------------------



Comment: Qty.: 0.7971 sf(s)/Unit Total : 6.3768 sf(s)

1010-1025 sheet .125

Batch: M102247 MA 061004

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3330

Dwg Rev: B1

Prog Rev: B1

2-Deburr if necessary

MA 061004
06/10/19

(8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MA 061004

(8)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

06/10/19

(8)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Deburr

Form as per Dwg D3330

MA 061004
06/10/23
505

06/10/25

(8)

(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-04	2.0	Hole is part was not made oblong at Ø.688 at 1.705' 1.605' locat. m.		Fix the DXF to complete oblong hole.	 06-10-23			
06-10-04	2.0	Hole was milled to .750.		Mill hole to correct size as per Dwg. acceptable.	 06/10/20			

NOTE: Date & initial all entries

Date: Monday, 25/09/2006 11:11:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 28627

Part Number: D33307

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 10-25

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

WS23

CPL 06-10-26

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/26

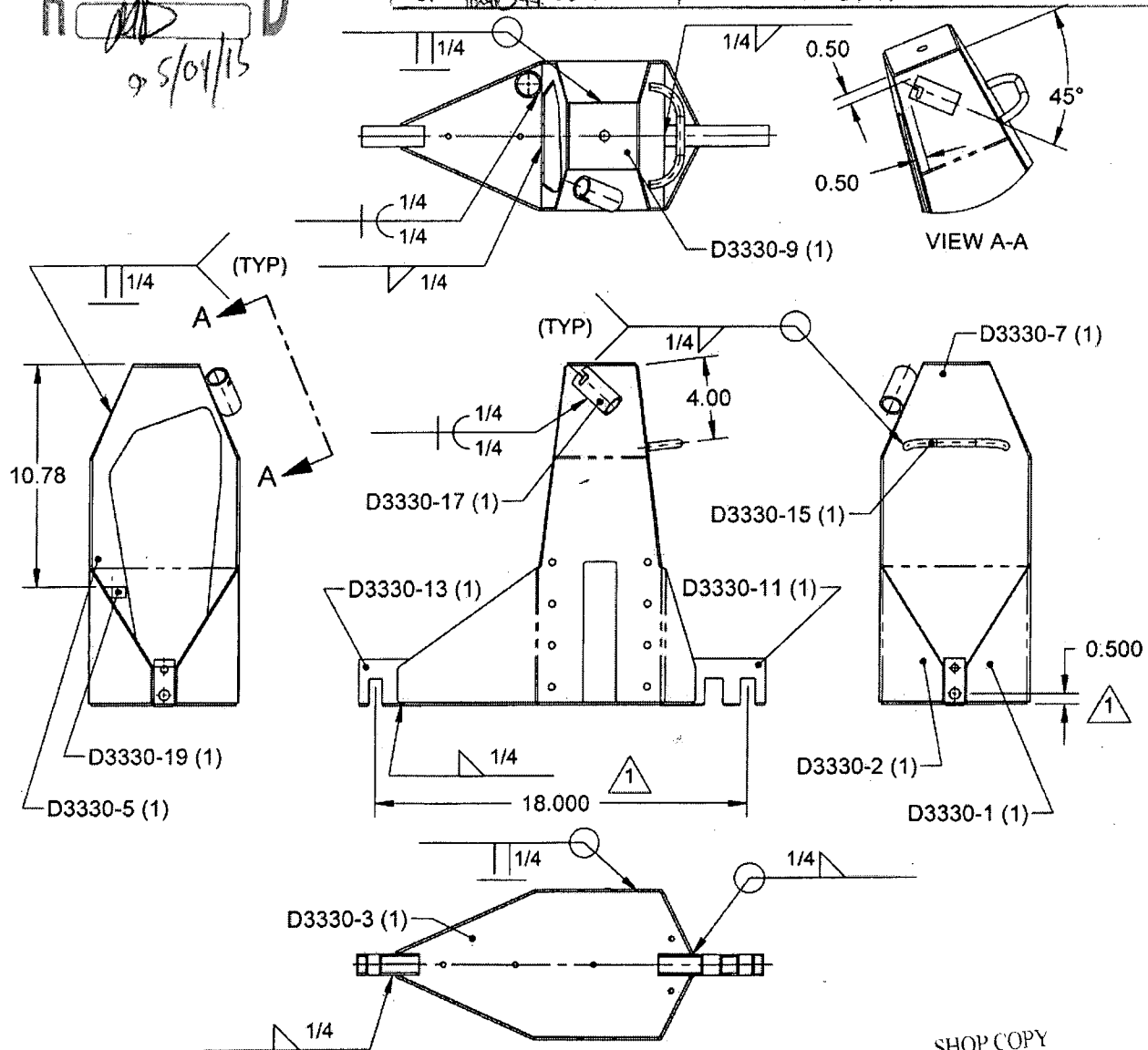
Job Completion



U 06-10-26

DART**RELEASED**
9/5/04/15

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3330	REV. B SHEET 1 OF 9
DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:8
A	04.12.16	NEW ISSUE	
B	05.02.26	REDESIGN	
BI	05.07.04	ADD 1.605 DIM.	

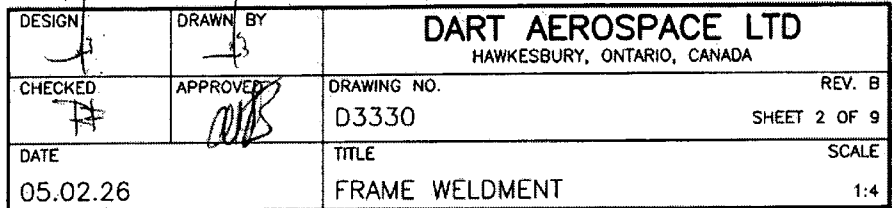
**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

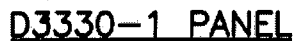
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05/04/15



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2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

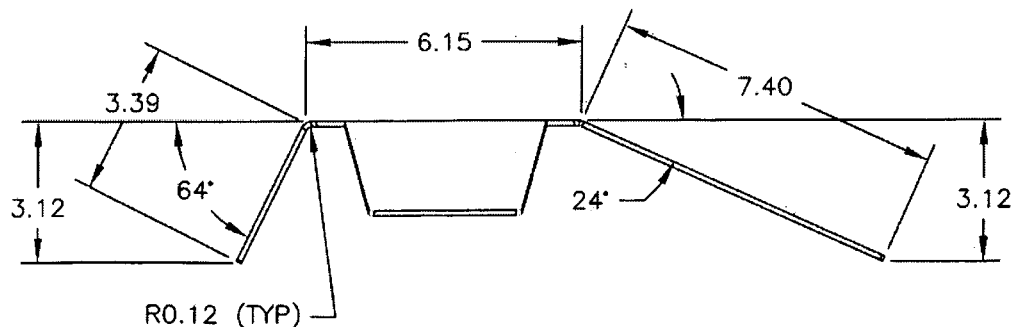
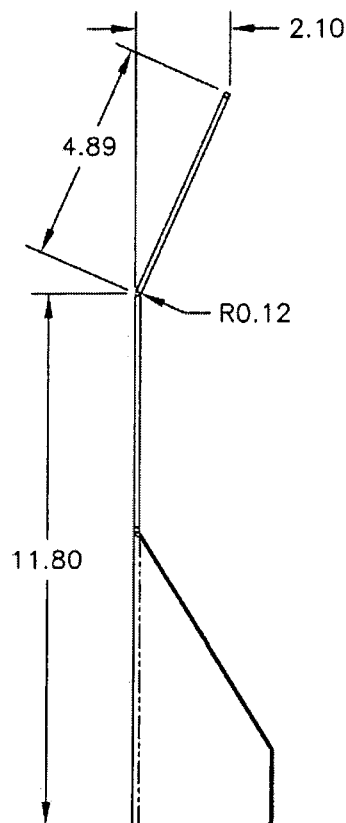
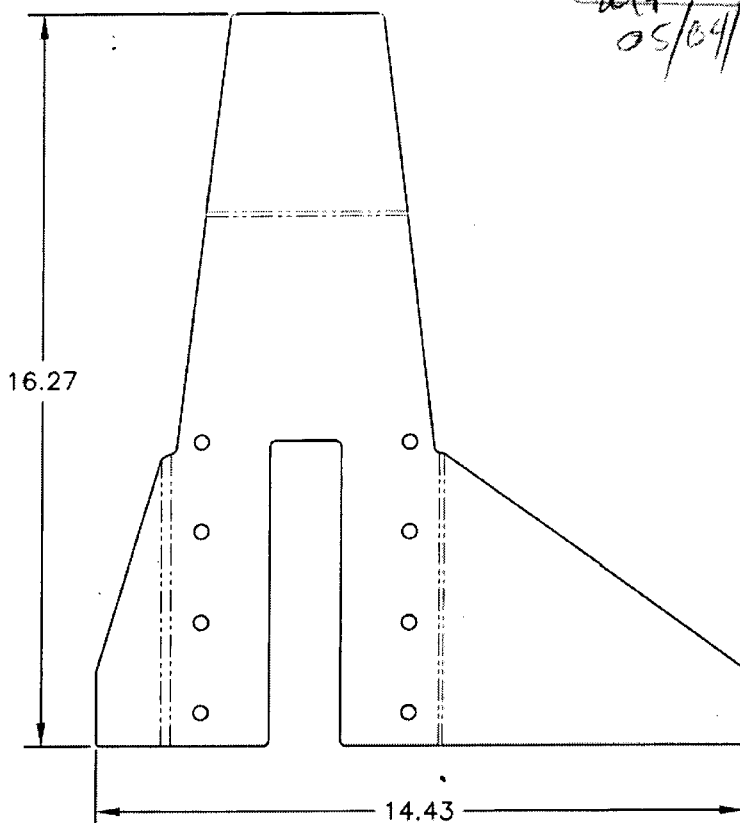
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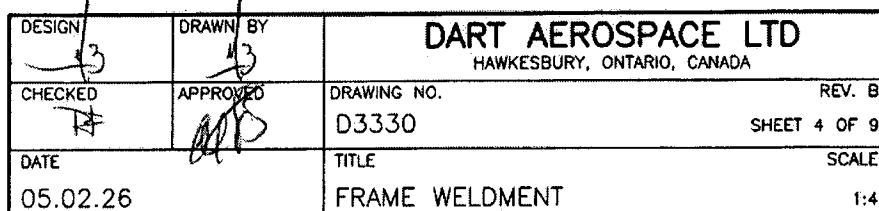


D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

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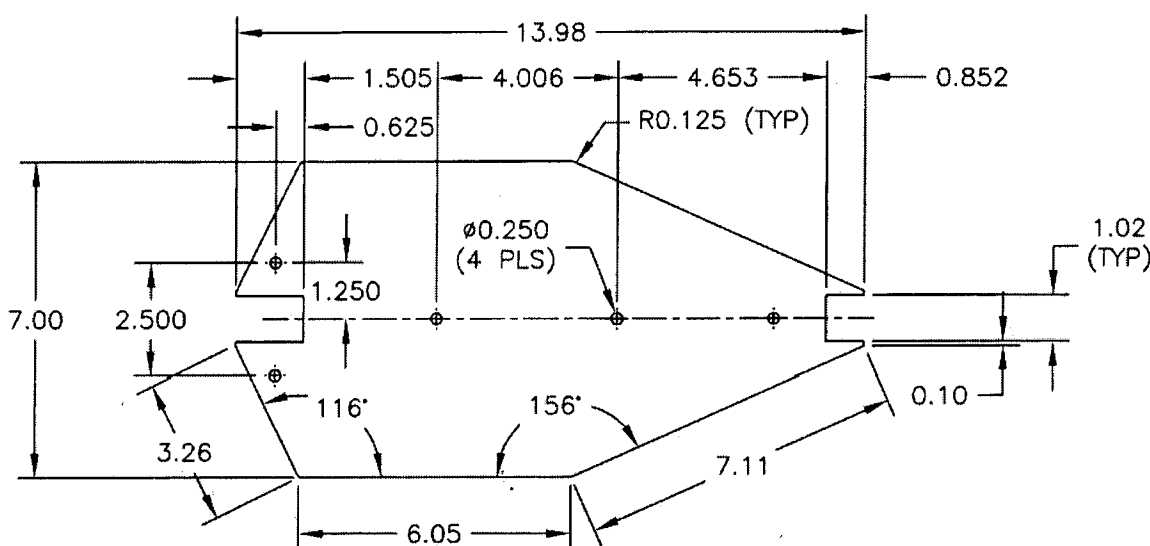
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D3330-3 PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40.21 CONTROLLED COPY
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK) TO AMENDMENT
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED WITHOUT NOTICE
3) ALL DIMENSIONS ARE IN INCHES WORK ORDER
4) BREAK ALL SHARP EDGES 0.005 TO 0.010 NO. 28627

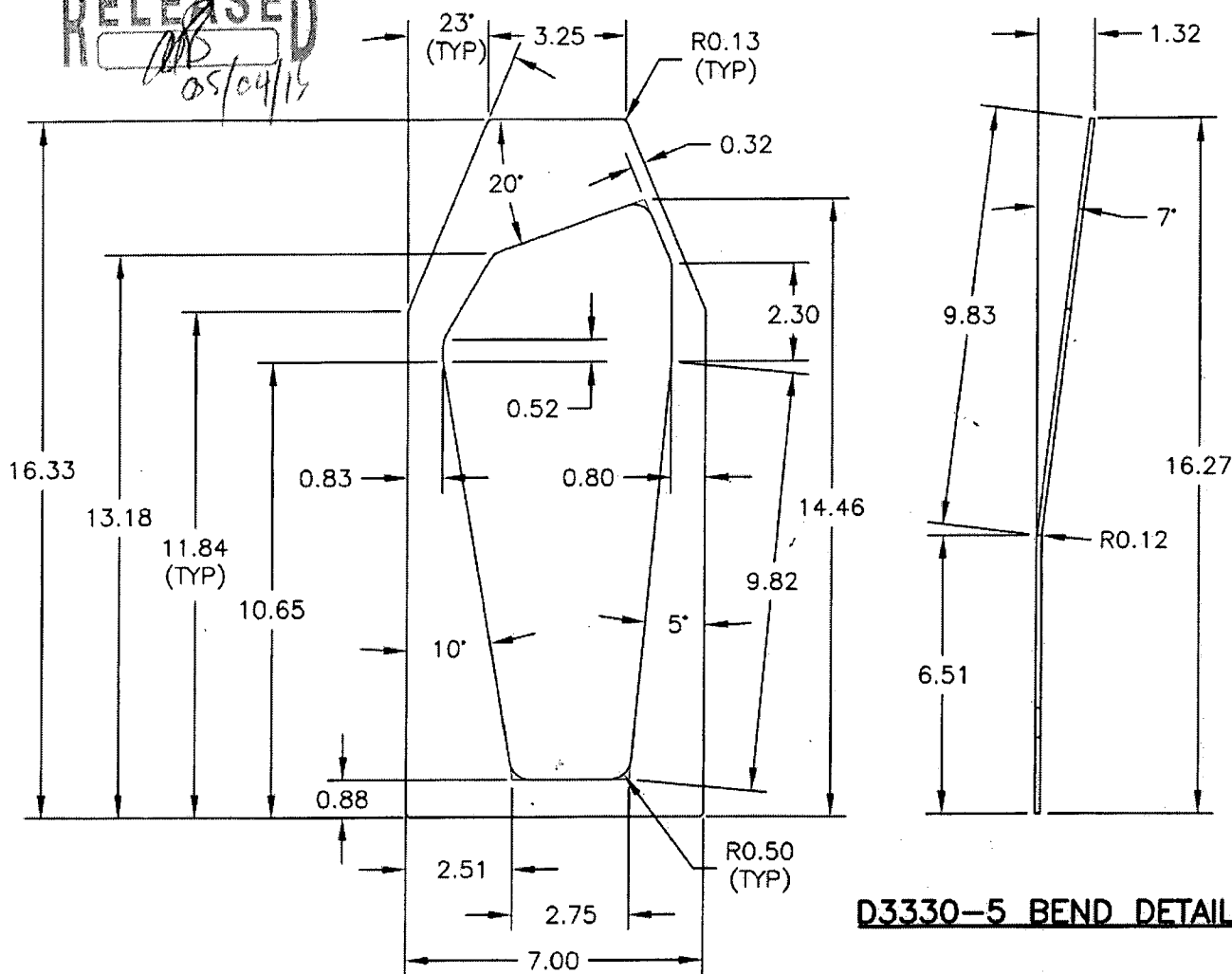
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:4



FLAT PATTERN

D3330-5 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.025 IN THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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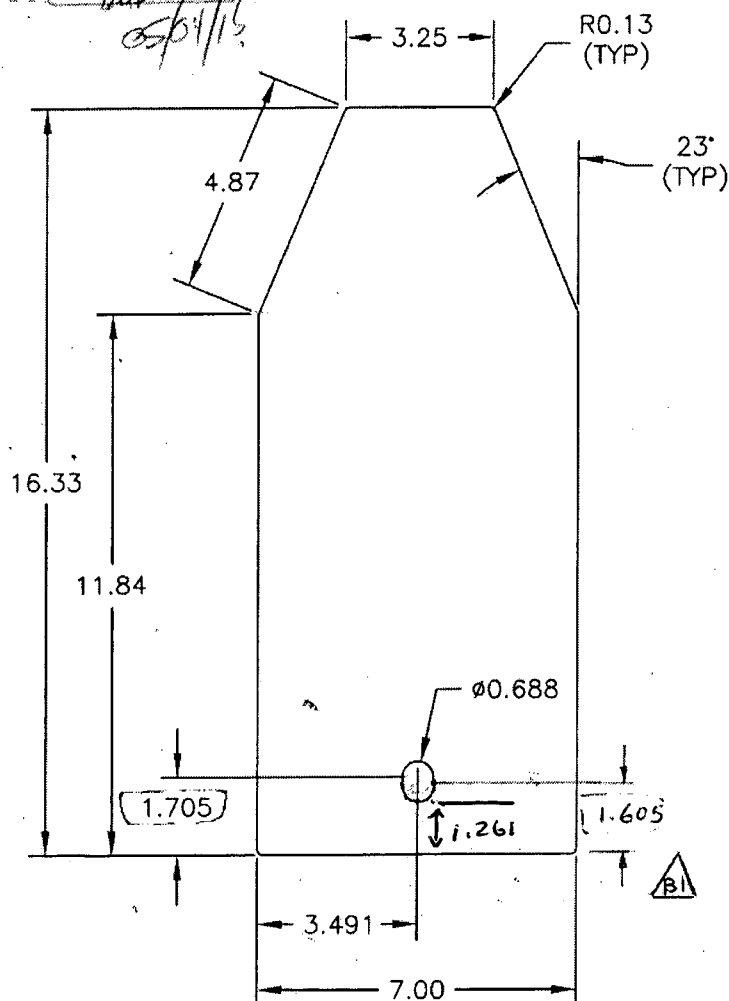
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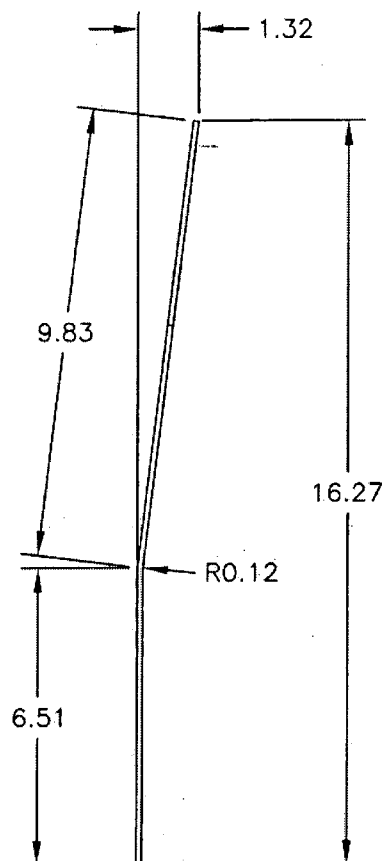


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osp/1/15



FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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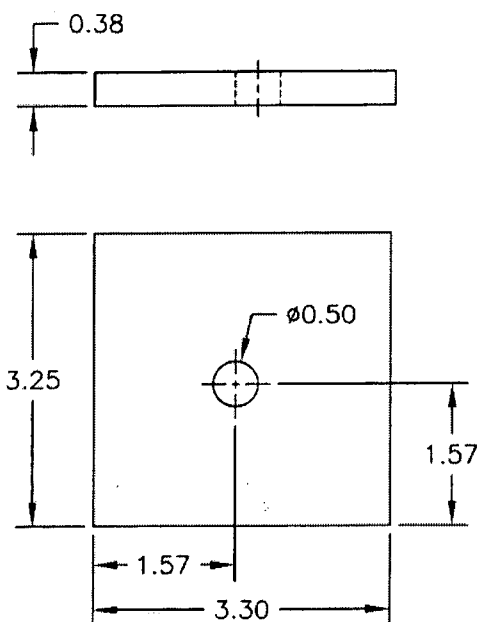
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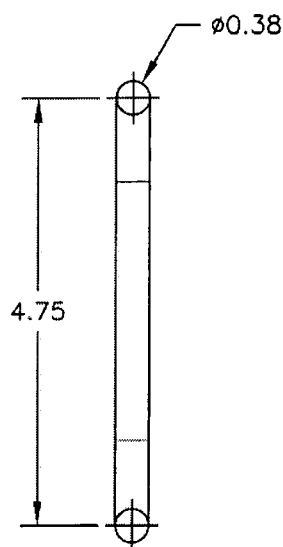
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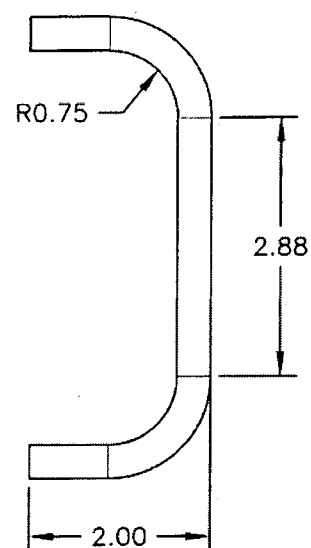
△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

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05/04/15



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

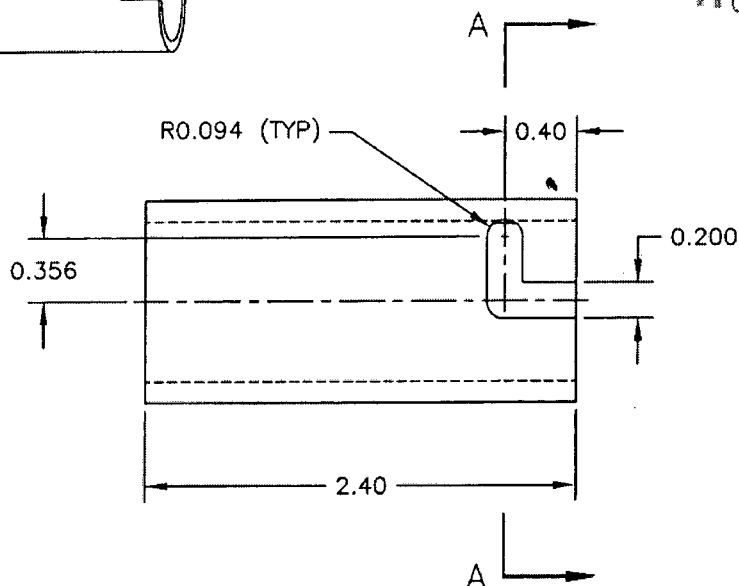
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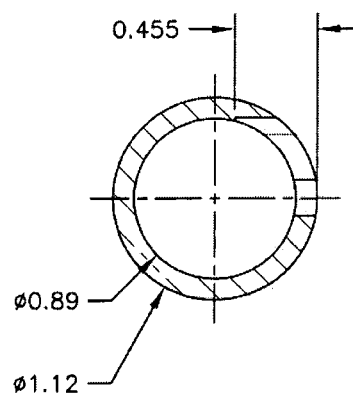
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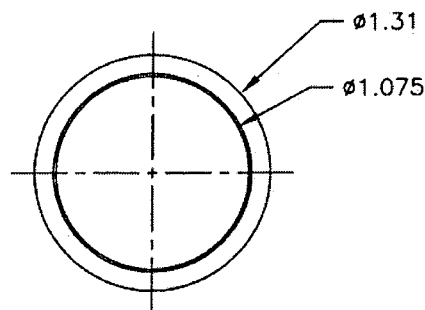
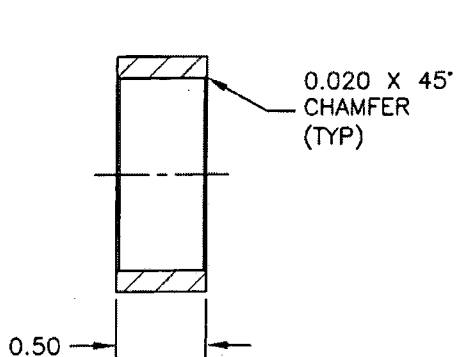


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SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

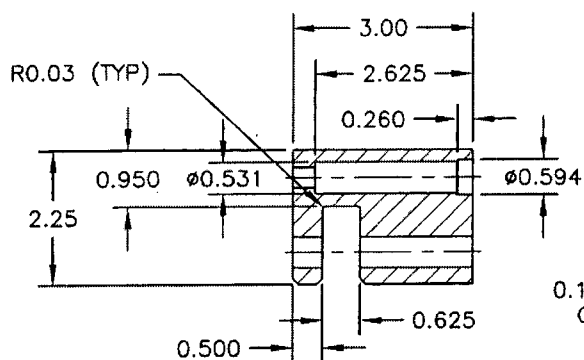
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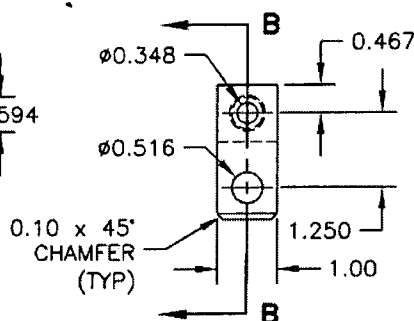
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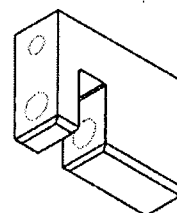
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DATE 05.02.26		TITLE FRAME WELDMENT	SCALE 1:3



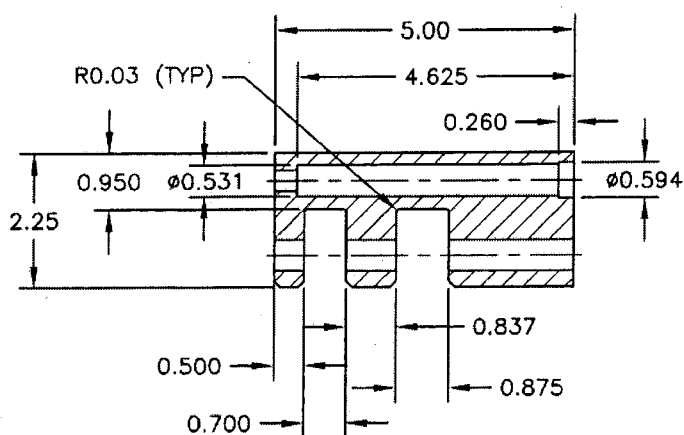
SECTION B-B



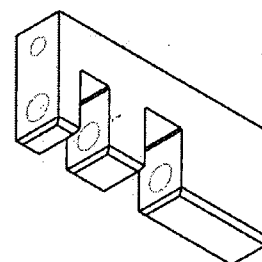
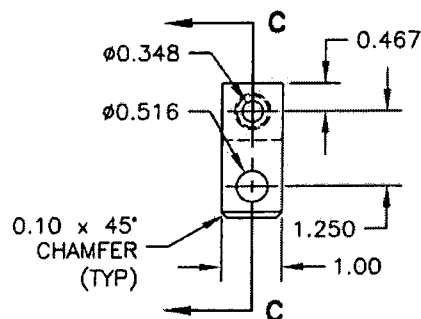
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05/04/15.



D3330-13 SHORT PIN BRACKET



SECTION C-C



D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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